

Work Order ID 82998

82998

Page 1

Thursday, April 12, 2012 10:26:14 AM

Item ID: D3945-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 4/12/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 4/26/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MF

Date: 12-04-12 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3945

A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3945-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(10)

Jim / [Signature]
12-4-15

(10)

Jim / [Signature]
12-4-15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00 *8/26/17*

Quality Control

(X10)

130

0.00

130

Small Fab

Memo

0.00

Small Fab

COUNTERSINK AS PER DWG

(10x) Ø

EP 12/04/17

140

0.00

140

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg

10 8

SP 12/04/18

Dart Aerospace Ltd

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sizkules		(40)			
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

⑩ MG12-420

10 12-4-20

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

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Start Date: 4/12/2012 **Start Qty:** 10.00 ***10***

Cust Item ID:

Required Date: 4/26/2012 **Req'd Qty:** 10.00 ***10***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool

Plan Code

**Accept
Qty**

Reject Qty

Reject Number

Insp.
Stamp

180

Pick Kit

0.00

180

Packaging

Memo

0.00

Packaging

190

0.00

190

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AS PER DWG

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: **874**

0.00

210

Packaging

Memo

0.00

Packaging

10x**SP**
12-04-27

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/4/30 **JD****12-04-27**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 12, 2012 10:26:14 AM

Page 1

Work Order ID: 82998

Parent Item: D3945-041

Parent Item Name: Bracket

Start Date: 4/12/2012

Required Date: 4/26/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050 6061-T6 .050 Sheet		Purchased	No			100	sf	245.7940	0.0118	0.1242105			

Location	Loc Qty	Loc Code
021	144	
1211920	144	
MAT021	101.794	
113216	10	
114799	76.794	
114993	15	

MS21059L3

Nut Plate

Purchased

No

180

Each

262.0000

1

10

Location	Loc Qty	Loc Code
302	100	
121185	100	
ST301	28	
118614	8	
119546	20	
ST302	134	
120308	13	
120833	21	
<u>121011</u>	100	

MS20426AD3-3

Rivet

Purchased

No

180

Each

3,817.0000

2

20

Location	Loc Qty	Loc Code
ST316	3817	
<u>119109</u>	655	
121011	2727	
19099	435	

20

Jm-nh
12-4-15

12/4/23

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

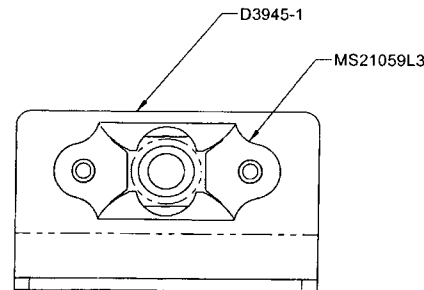
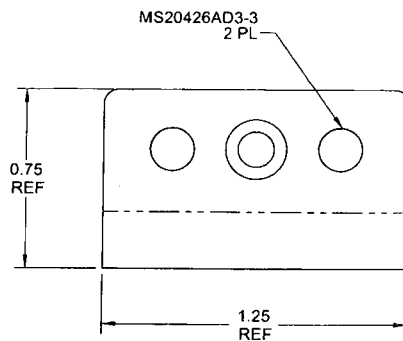
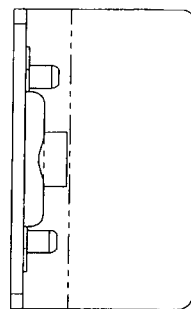
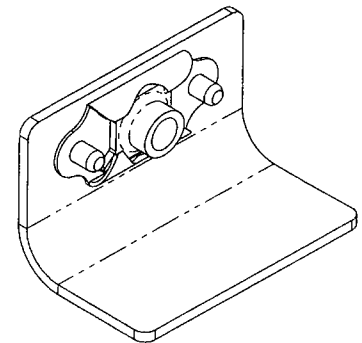
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3945-041	BRACKET
2	1	D3945-1	BRACKET
3	1	MS21059L3	NUTPLATE
4	2	MS20426AD3-3	RIVET



D3945-041 BRACKET

82998

RELEASED
09/06/16

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3945-041" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.01 lbs

REV.	DESCRIPTION	CP	DATE
A	NEW ISSUE		09.05.01
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3945** REV. A
SHEET 1 OF 3
TITLE **BRACKET** SCALE NTS

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Dart Aerospace Ltd

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

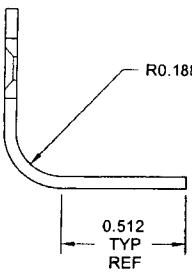
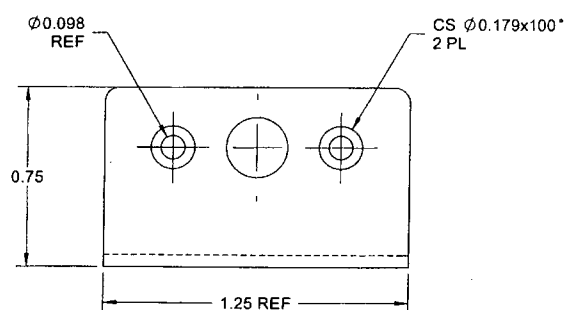
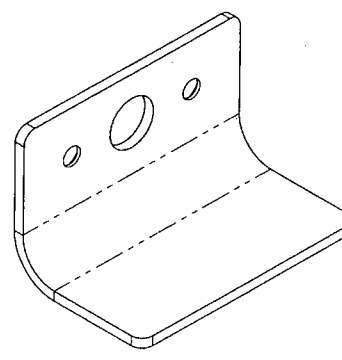
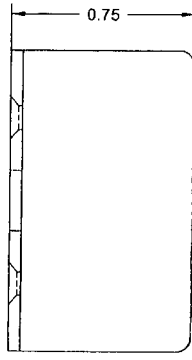
A

D

C

B

A



#82998

D3945-1 BRACKET

RELEASED
09/06/01

NOTES:

- 1) MATERIAL: MAKE FROM D3945-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3945	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.05.01	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

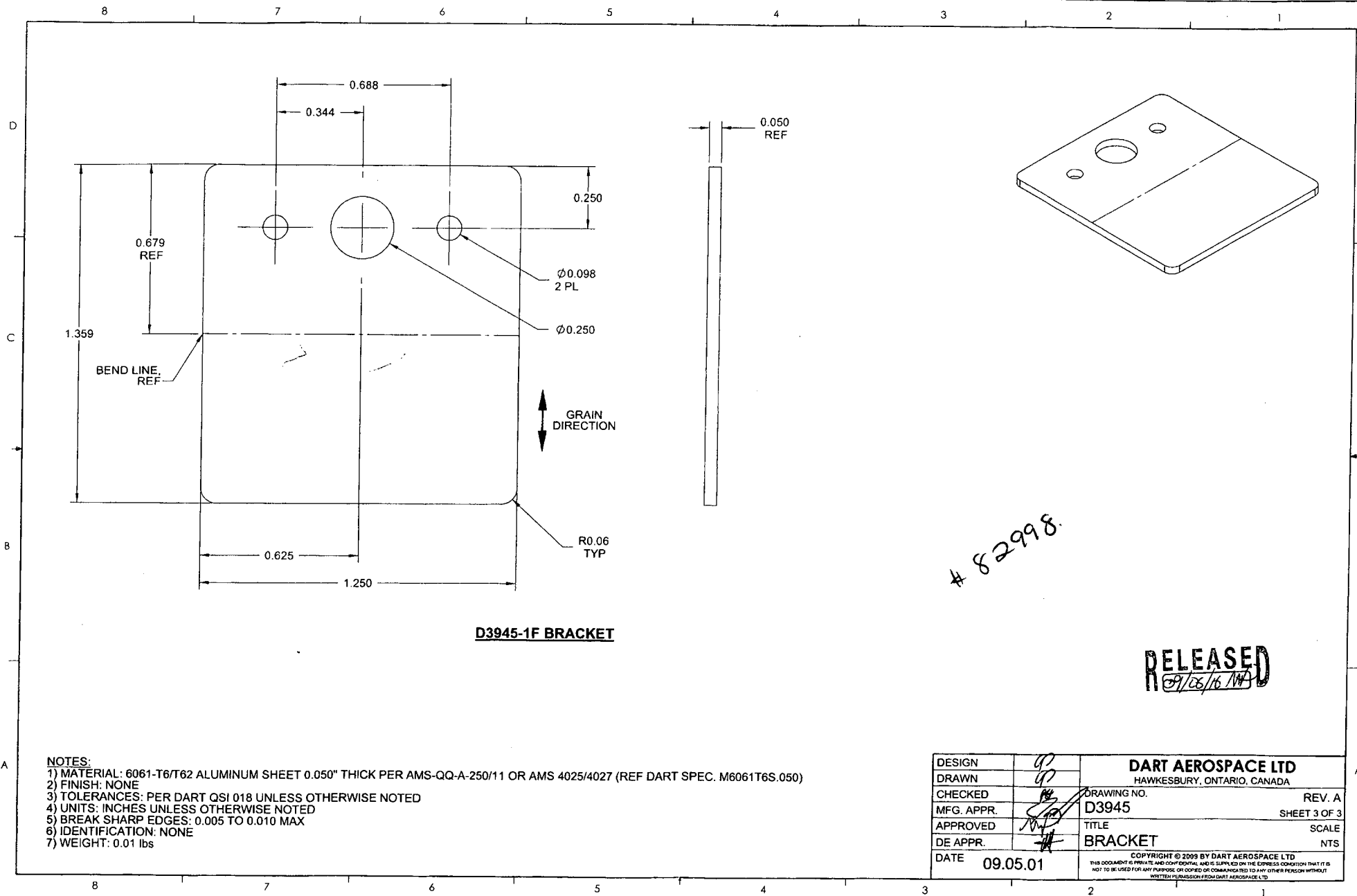
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